

5/25

3

| | | |
|---|---------------------|-------------|
| DART AEROSPACE LTD | Work Order: | 23306 |
| Description: Doubler | Part Number: | D3302-1 |
| Dwg: D3302 Rev. <i>04.11.25</i> <i>04.12.16</i> | Qty: | 20 |
| | | Page 1 of 1 |


| Step | Location | Procedure | By | Date | Qty |
|------|----------|---|-------------|----------|-----|
| 1 | DC | Issue Traveler Note: To be made in multiples of 10 | <i>18</i> | 05.05.20 | 20 |
| 2 | MV | Cut blank: 12.900 x 7.850" <i>13.150"</i> Material: 6061-T6 (QQ-A-250/11) 0.063" thick (M6061T6S.063) Identify for D3302-1 Batch: <i>M17400</i> | <i>36</i> | 05/06/08 | 20 |
| 3 | MV | Machine as per Folio FA450 and Dwg D3302 Stack of 10 Identify as D3302-1 | <i>J.L</i> | 05/06/10 | 20 |
| 4 | QC2 | Inspect parts as they come off the CNC machine | <i>J.L</i> | 05/06/10 | 20 |
| 5 | QC8 | Second check | <i>EL</i> | 05.06.10 | 20 |
| 6 | GA | Deburr break all unmarked sharp edges 0.005 to 0.010 | <i>E.T.</i> | 05/06/16 | 20 |
| 7 | GB | Form as per Dwg D3302 | <i>EB</i> | 05/08/25 | 20 |
| 8 | QC5 | Inspect work to Step 7 | <i>2</i> | 05-08-01 | 20 |
| 9 | FP | Chemical Conversion Coat as per QSI 005 4.1 | <i>DM</i> | 05-09-9 | 20 |
| 10 | QC3 | Inspect Chemical Conversion Coat | <i>MM</i> | 05.09.12 | 20 |
| 11 | ST | Identify and Stock | <i>DL</i> | 05/09/13 | 20 |
| 12 | AC | Cost / part <i>16.99</i> | <i>S4C</i> | 05.09.14 | 20 |
| 13 | DC | Close W/O <i>16.04</i> Inspect Level 21 | <i>17</i> | 05/09/14 | 20 |

| Rev | Date | Change | Revised By | Approved |
|-----|----------|-----------|------------|--------------------|
| A | 04.09.02 | New issue | KJ/JLM | <i>[Signature]</i> |

RELEASED
[Signature] 05/09/08

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 05/09/14

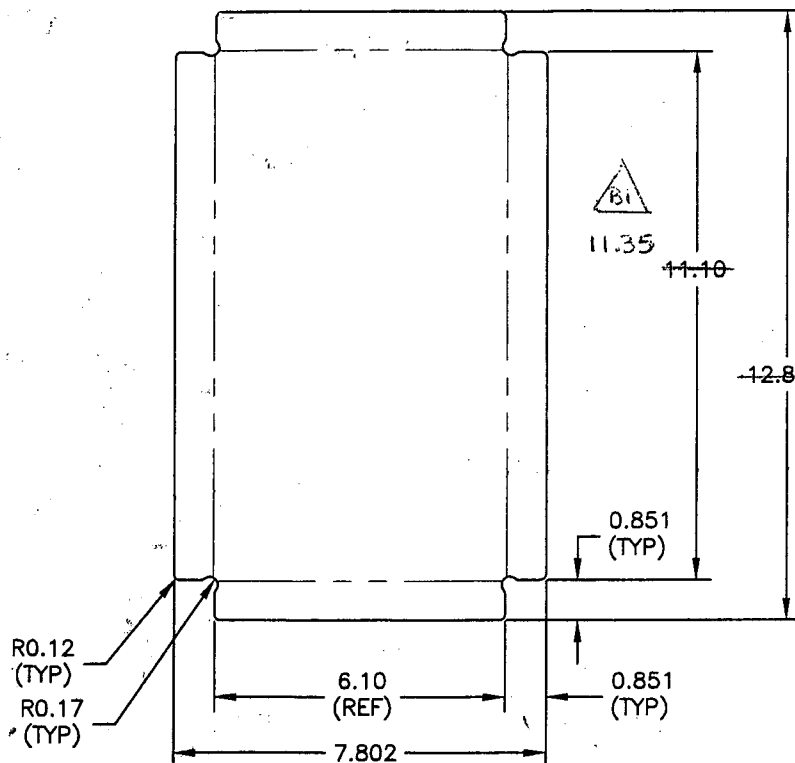
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

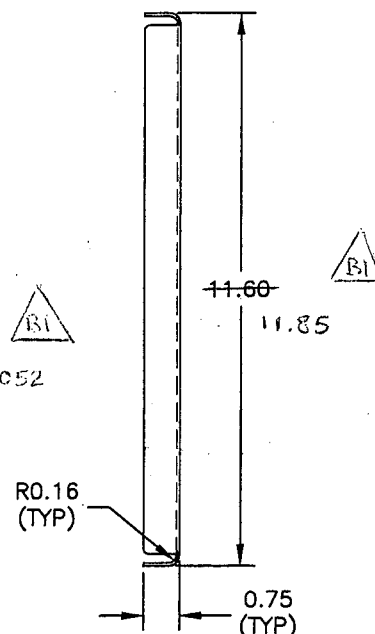


| | | | |
|------------------|------------------|---|------------------------|
| DESIGN T# | DRAWN BY T# | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED H | APPROVED H | DRAWING NO. D3302 | REV. B SHEET 1 OF 4 |
| DATE 04.11.18 | TITLE DOUBLER | SCALE 1:4 | |
| A | 04.07.06 | NEW ISSUE | |
| B | 04.11.18 | REMOVE HOLES | |
| Bi | RF 04.12.15 | ADDED 0.25" TO THE LENGTH FOR -1/-3 | |
| B2 | RF 05.03.21 | 7.25 WAS 7.34; 8.952 WAS 9.042; 7.75 WAS 7.84 FOR D3302-3 | |

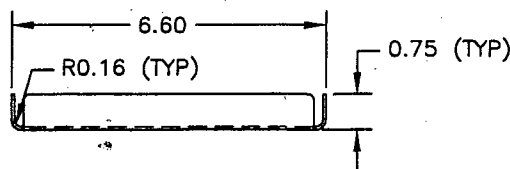
RELEASED
04.11.23



D3302-1 FLAT PATTERN



D3302-1 DOUBLER
BEND DETAIL



D3302-1 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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SUCH AS FOR IDENTIFICATION
FROM NOTICE

WORK ORDER

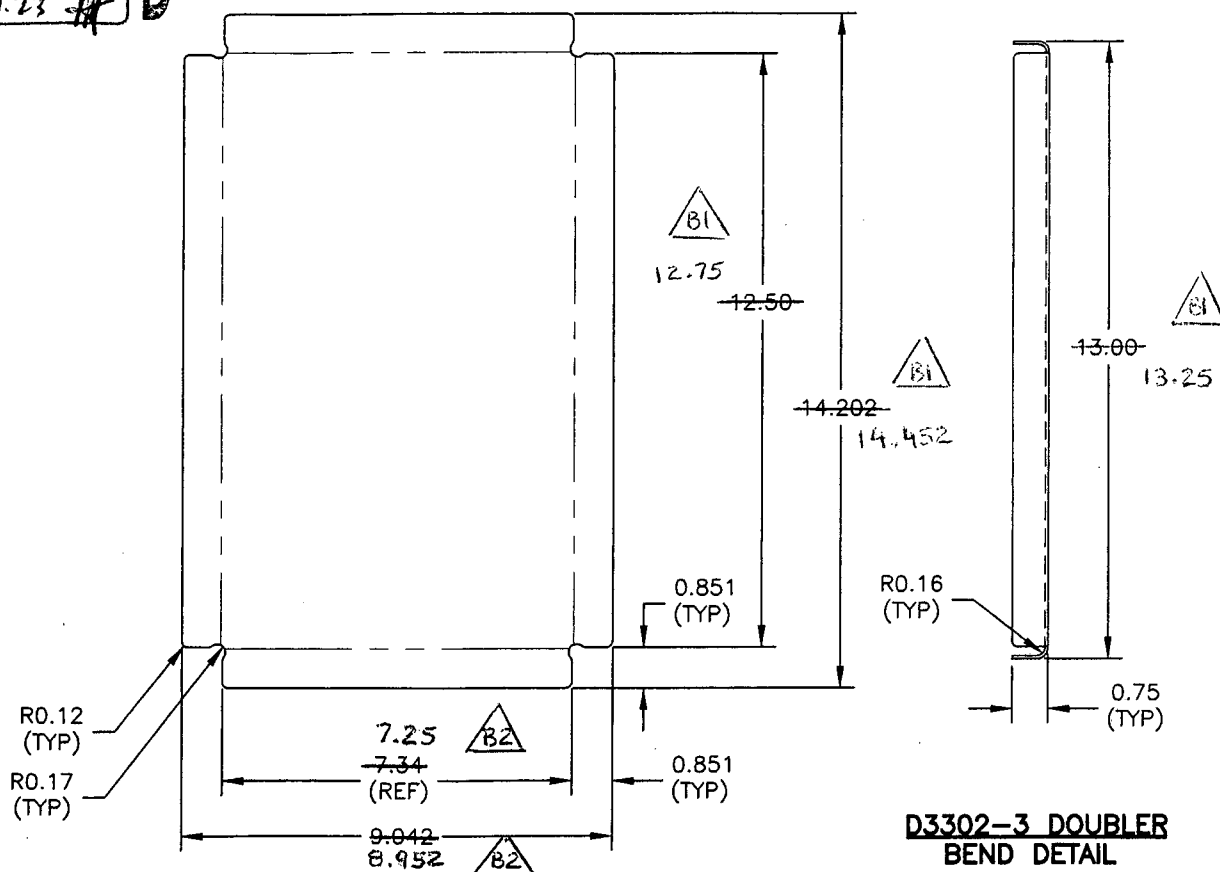
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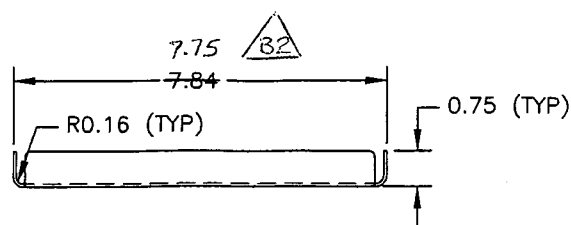


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|------------------|----------------|---|------------------------|
| DESIGN RT | DRAWN BY RT | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED RT | APPROVED RT | DRAWING NO. D3302 | REV. B SHEET 2 OF 4 |
| DATE 04.11.18 | | TITLE DOUBLER | SCALE 1:4 |

RELEASED
04.11.23 RT



D3302-3 FLAT PATTERN



D3302-3 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & BATCH USING FINE POINT PERMANENT MARKER

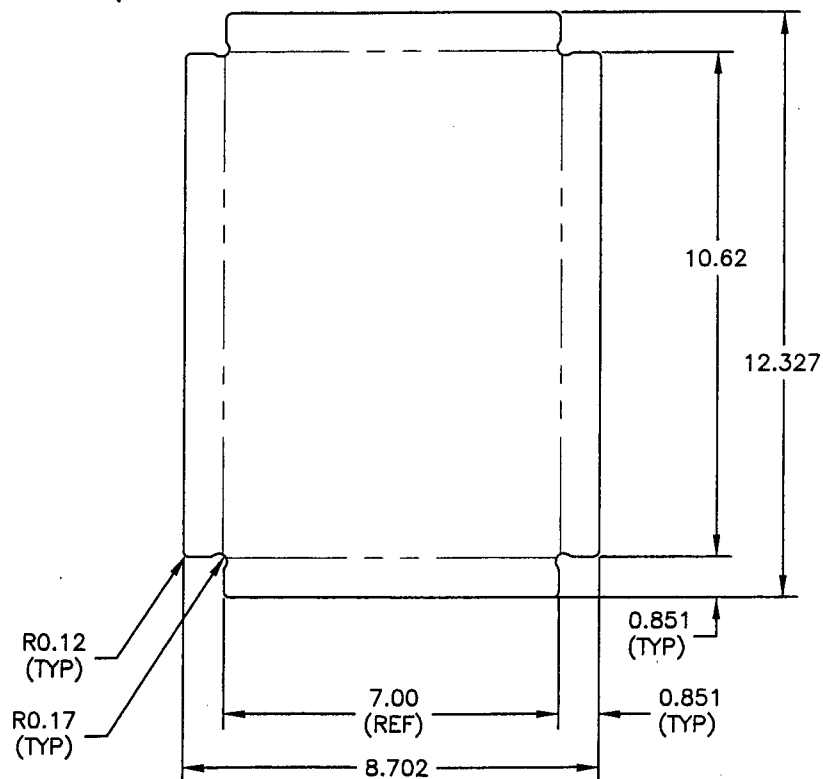
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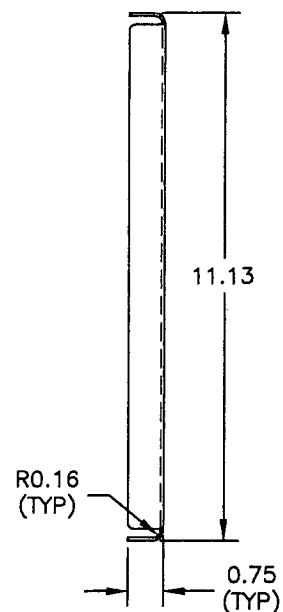
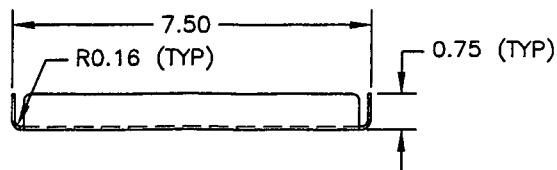


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|------------------|----------------|---|------------------------|
| DESIGN RF | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED H | APPROVED H | DRAWING NO. D3302 | REV. B SHEET 3 OF 4 |
| DATE 04.11.08 | | TITLE DOUBLER | SCALE 1:4 |

RELEASED
04.11.23



D3302-5 FLAT PATTERN



**D3302-5 DOUBLER
BEND DETAIL**

SHORT COPY
FROM TO
COPY TO

U IT COPY
S E ELEMENT
H TICE

WORK ORDER

NO. 23306

D3302-5 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

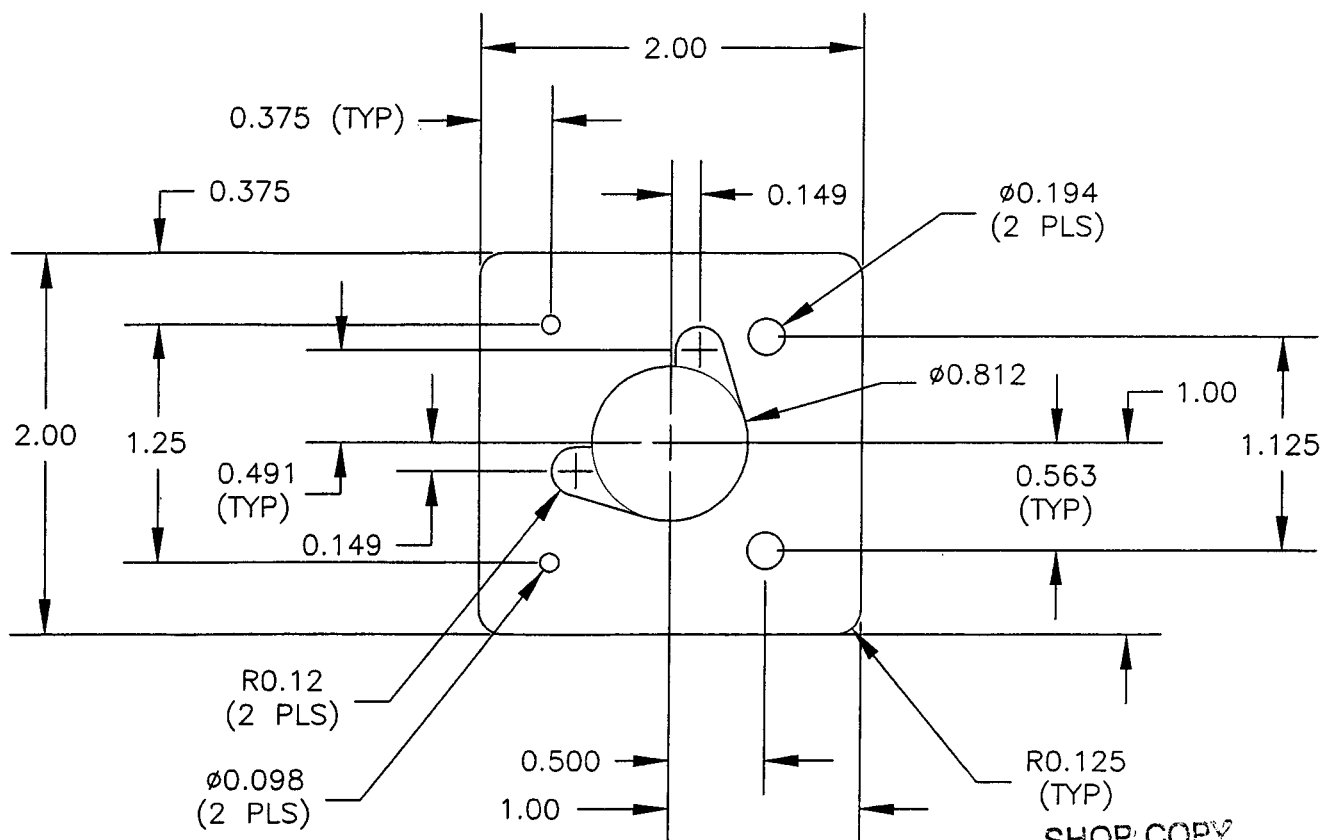
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| | | | |
|------------------------|-------------------------|---|------------------------|
| DESIGN RF | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D3302 | REV. B SHEET 4 OF 4 |
| DATE 04.11.18 | | TITLE DOUBLER | SCALE 1:1 |

RELEASED
04.11.23



D3302-7

D3302-7 NOTES:

- 1) MATERIAL: 5052-H32 OR 6061-T6 (QQ-A-250/8 OR QQ-A-250/11) 0.040 THICK (REF. DART SPEC. M5052H32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 12, 2005
04:28 pm

Work Order No : 0023306
Project Name : D3302-1
Project For : WK525
Work Order Type : Main
Main WO Number :
House Part Number : D3302-1
Description : Doubler
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 05-12-05
Est Finish Date : 06-23-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

| | Estimated | Actual | Var. % | Posted | To Post |
|-------------------|-----------|--------|--------|--------|---------|
| Material Cost | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Engineering Hours | 0.00 | 0.00 | 0.00 | | |
| Engineering Cost | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Production Hours | 0.00 | 0.00 | 0.00 | | |
| Production Cost | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Packaging Hours | 0.00 | 0.00 | 0.00 | | |
| Packaging Cost | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| OverHead Hours | 0.00 | 0.00 | 0.00 | | |
| OverHead Cost | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| CNC Hours | 0.00 | 0.00 | 0.00 | | |
| CNC | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Misc. Hours | 0.00 | 0.00 | 0.00 | | |
| Misc. | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Burden | 0.00 | 0.00 | 0.00 | | |
| Total Cost | 0.00 | 0.00 | 0.00 | | |
| Mark up | 0.000 | 0.000 | | | |
| Selling Cost | 0.00 | 0.00 | | | |

| | | |
|------------------------|-----------|--------|
| | Estimated | Actual |
| Labour Hrs/Amount Done | 0.00 | 0.00 |
| Profits/(Loss) | 0.00 | 0.00 |